



User Manual

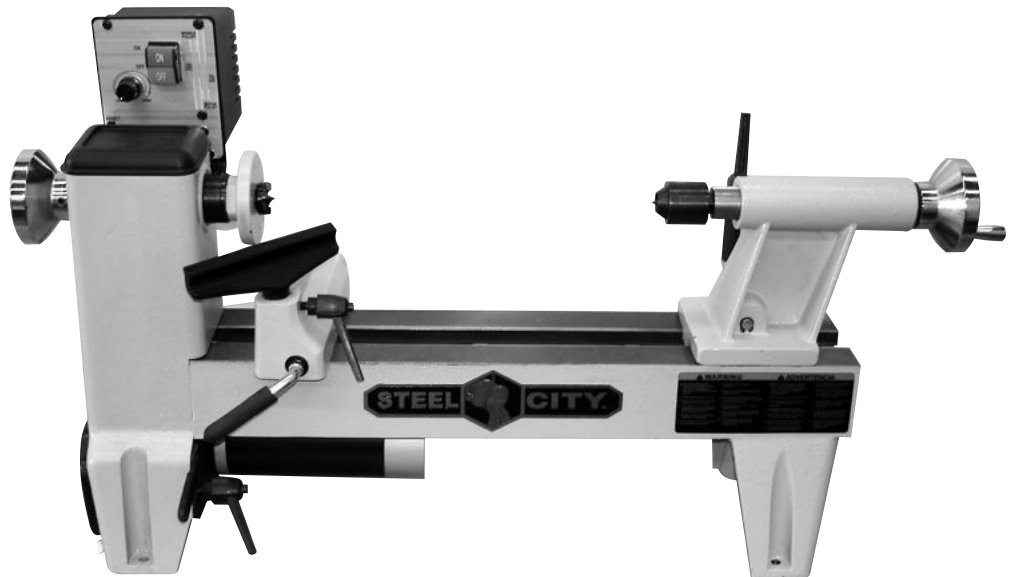
Read and understand this manual before using machine.

MINI LATHE



**Model Number
60170
(5-Speed)**

**Model Number
60100
(Variable Speed)**



STEEL CITY TOOL WORKS

Manual Part No. OR71661



THANK YOU for purchasing your new Steel City Mini Lathe. This mini lathe has been designed, tested, and inspected with you, the customer, in mind. When properly used and maintained, your mini lathe will provide you with years of trouble free service, which is why it is backed by one of the longest machinery warranties in the business.

This mini lathe is just one of many products in the Steel City's family of woodworking machinery and is proof of our commitment to total customer satisfaction.

At Steel City we continue to strive for excellence each and every day and value the opinion of you, our customer. For comments about your mini lathe or Steel City Tool Works, please visit our web site at **www.steelcitytoolworks.com** .

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INTRODUCTION

This user manual is intended for use by anyone working with this machine. It should be kept available for immediate reference so that all operations can be performed with maximum efficiency and safety. Do not attempt to perform maintenance or operate this machine until you have read and understand the information contained in this manual.

The drawings, illustrations, photographs, and specifications in this user manual represent your machine at time of print. However, changes may be made to your machine or this manual at any time with no obligation to Steel City Tool Works.

WARRANTY

STEEL CITY TOOL WORKS 5 YEAR LIMITED WARRANTY

Steel City Tool Works, LLC (“SCTW”) warrants all “STEEL CITY TOOL WORKS” machinery to be free of defects in workmanship and materials for a period of 5 years from the date of the original retail purchase by the original owner. SCTW will repair or replace, at its expense and at its option, any SCTW machine, machine part, or machine accessory which in normal use has proven to be defective, provided that the customer returns the product, shipping prepaid, to an authorized service center with proof of purchase and provides SCTW with a reasonable opportunity to verify the alleged defect by inspection. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, or lack of maintenance, or to repairs or alterations made or specifically authorized by anyone other than SCTW. Normal wear components are also excluded under this coverage. Every effort has been made to ensure that all SCTW machinery meets the highest quality and durability standards. We reserve the right to change specifications at any time due to our commitment to continuous improvement of the quality of our products.

EXCEPT AS SET FORTH ABOVE, SCTW MAKES NO EXPRESS OR IMPLIED REPRESENTATIONS OR WARRANTIES WITH RESPECT TO ITS MACHINERY, OR ITS CONDITION, MERCHANTABILITY, OR FITNESS FOR ANY PARTICULAR PURPOSE OR USE. SCTW FURNISHES THE ABOVE WARRANTIES IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, WHICH ARE HEREBY SPECIFICALLY DISCLAIMED.

SCTW SHALL NOT BE LIABLE FOR ANY (A) SPECIAL, INDIRECT, INCIDENTAL, PUNITIVE OR CONSEQUENTIAL DAMAGES, INCLUDING WITHOUT LIMITATION LOSS OF PROFITS, ARISING FROM OR RELATED TO THIS WARRANTY, THE BREACH OF ANY AGREEMENT OR WARRANTY, OR THE OPERATION OR USE OF ITS MACHINERY, INCLUDING WITHOUT LIMITATION DAMAGES ARISING FROM DAMAGE TO FIXTURES, TOOLS, EQUIPMENT, PARTS OR MATERIALS, DIRECT OR INDIRECT LOSS CAUSED BY ANY OTHER PARTY, LOSS OF REVENUE OR PROFITS, FINANCING OR INTEREST CHARGES, AND CLAIMS BY ANY THIRD PERSON, WHETHER OR NOT NOTICE OF SUCH POSSIBLE DAMAGES HAS BEEN GIVEN TO SCTW; (B) DAMAGES OF ANY KIND FOR ANY DELAY BY OR FAILURE OF SCTW TO PERFORM ITS OBLIGATIONS UNDER THIS AGREEMENT; OR (C) CLAIMS MADE A SUBJECT OF A LEGAL PROCEEDING AGAINST SCTW MORE THAN ONE (1) YEAR AFTER SUCH CAUSE OF ACTION FIRST AROSE.

The validity, construction and performance of this Warranty and any sale of machinery by SCTW shall be governed by the laws of the Commonwealth of Pennsylvania, without regard to conflicts of laws provisions of any jurisdiction. Any action related in any way to any alleged or actual offer, acceptance or sale by SCTW, or any claim related to the performance of any agreement including without limitation this Warranty, shall take place in the federal or state courts in Allegheny County, Pennsylvania.

STEEL CITY TOOL WORKS

WARRANTY CARD

Name _____
 Street _____
 Apt. No. _____
 City _____ State _____ Zip _____
 Phone Number _____
 E-Mail _____

Product Description: _____
 Model No.: _____
 Serial No. _____

***The following information is given on a voluntary basis
 and is strictly confidential.***

1. Where did you purchase your STEEL CITY machine?
 Store: _____
 City: _____

2. How did you first learn of Steel City Tool Works?
 _____ Advertisement _____ Mail Order Catalog
 _____ Web Site _____ Friend
 _____ Local Store _____ Other _____

3. Which of the following magazines do you subscribe to?
 _____ American Woodworker _____ American How-To
 _____ Cabinetmaker _____ Family Handyman
 _____ Fine Homebuilding _____ Fine Woodworking
 _____ Journal of Light Construction _____ Old House Journal
 _____ Popular Mechanics _____ Popular Science
 _____ Popular Woodworking _____ Today's Homeowner
 _____ WOOD _____ Woodcraft
 _____ WOODEN Boat _____ Woodshop News
 _____ Woodsmith _____ Woodwork
 _____ Woodworker _____ Woodworker's Journal
 _____ Workbench _____ Other _____

4. Which of the following woodworking / remodeling shows do you watch?
 _____ Backyard America _____ The American Woodworker
 _____ Home Time _____ The New Yankee Workshop
 _____ This Old House _____ Woodwright's Shop
 Other _____

5. What is your annual household income?
 _____ \$20,000 to \$29,999 _____ \$30,000 to \$39,999
 _____ \$40,000 to \$49,999 _____ \$50,000 to \$59,999
 _____ \$60,000 to \$69,999 _____ 70,000 to \$79,999
 _____ \$80,000 to \$89,999 _____ \$90,000 +

6. What is your age group?
 _____ 20 to 29 years _____ 30 to 39 years
 _____ 40 to 49 years _____ 50 to 59 years
 _____ 60 to 69 years _____ 70 + years

7. How long have you been a woodworker?
 _____ 0 to 2 years _____ 2 to 8 years
 _____ 8 to 20 years _____ over 20 years

8. How would you rank your woodworking skills?
 _____ Simple _____ Intermediate
 _____ Advance _____ Master Craftsman

9. How many Steel City machines do you own? _____

10. What stationary woodworking tools do you own?
Check all that apply.
 _____ Air Compressor _____ Band Saw
 _____ Drill Press _____ Drum Sander
 _____ Dust Collection _____ Horizontal Boring Machine
 _____ Jointer _____ Lathe
 _____ Mortiser _____ Panel Saw
 _____ Planer _____ Power Feeder
 _____ Radial Arm Saw _____ Shaper
 _____ Spindle Sander _____ Table Saw
 _____ Vacuum Veneer Press _____ Wide Belt Sander
 Other _____

11. Which benchtop tools do you own? *Check all that apply.*
 _____ Belt Sander _____ Belt / Disc Sander
 _____ Drill Press _____ Band Saw
 _____ Grinder _____ Mini Jointer
 _____ Mini Lathe _____ Scroll Saw
 _____ Spindle / Belt Sander _____ Other _____

12. Which portable / hand held power tools do you own?
Check all that apply.
 _____ Belt Sander _____ Biscuit Jointer
 _____ Dust Collector _____ Circular Saw
 _____ Detail Sander _____ Drill / Driver
 _____ Miter Saw _____ Orbital Sander
 _____ Palm Sander _____ Portable Thickness Planer
 _____ Saber Saw _____ Reciprocating Saw
 _____ Router _____ Other _____

13. What machines / accessories would you like to see added to the STEEL CITY line?

14. What new accessories would you like to see added?

15. Do you think your purchase represents good value?
 _____ Yes _____ No

16. Would you recommend STEEL CITY products to a friend?
 _____ Yes _____ No

17. Comments:

FOLD ON DOTTED LINE

PLACE
STAMP
HERE

Steel City Tool Works
P.O. Box 10529
Murfreesboro, TN 37129

FOLD ON DOTTED LINE

PRODUCT SPECIFICATIONS

60100 Mini Lathe

Variable Speed

60170 Mini Lathe

5-Speed

MOTOR

Continuous Duty HP	1/2 HP	1/2 HP
Amps	3	5.6
Voltage	115V DC	115V AC
Phase	Single	Single
Hertz	60 Hz	60 Hz
RPM	500-3800	1725

SPECIFICATIONS

Swing Over Bed	10"	10"
Swing Over Tool Rest Base	7-1/2"	7-1/2"
Working Distance Between Centers	15"	15"
Range of Speeds (RPM)	500-1350, 1400-3800	500, 1300, 2100, 2750, 3600
Number of Speeds	N/A	5
Hole Through Spindle	3/8"	3/8"
Headstock Spindle Taper	#2 MT	#2 MT
Tailstock Spindle Taper	#2 MT	#2 MT
Hole Through Tailstock	3/8"	3/8"
Toolrest Length	6"	6"

PRODUCT DIMENSIONS

Length	28-3/4"	28-3/4"
Width	10"	10"
Height	18-1/2"	18-1/2"
Net Weight	72 lbs.	70 lbs.

SHIPPING DIMENSIONS

Carton Type	Cardboard Box	Cardboard Box
Length	30"	30"
Width	20"	20"
Height	12"	12"
Gross Weight	80 lbs.	78 lbs.

ACCESSORIES AND ATTACHMENTS

There are a variety of accessories available for your Steel City Product. For more information on any accessories associated with this and other machines, please contact your nearest Steel City distributor, or visit our website at: www.steelcitytoolworks.com.

DEFINITION OF TERMS

Banjo - The part on the lathe which slides along the bed and supports the tool rest.

Bed - The horizontal part of the lathe which connects the headstock and tailstock.

Chisel - A woodturning tool which is ground with a bevel.

Chuck - A device which holds the workpiece on the lathe.

Faceplate - Fastens to the headstock and is used for face turning operations such as making a bowl.

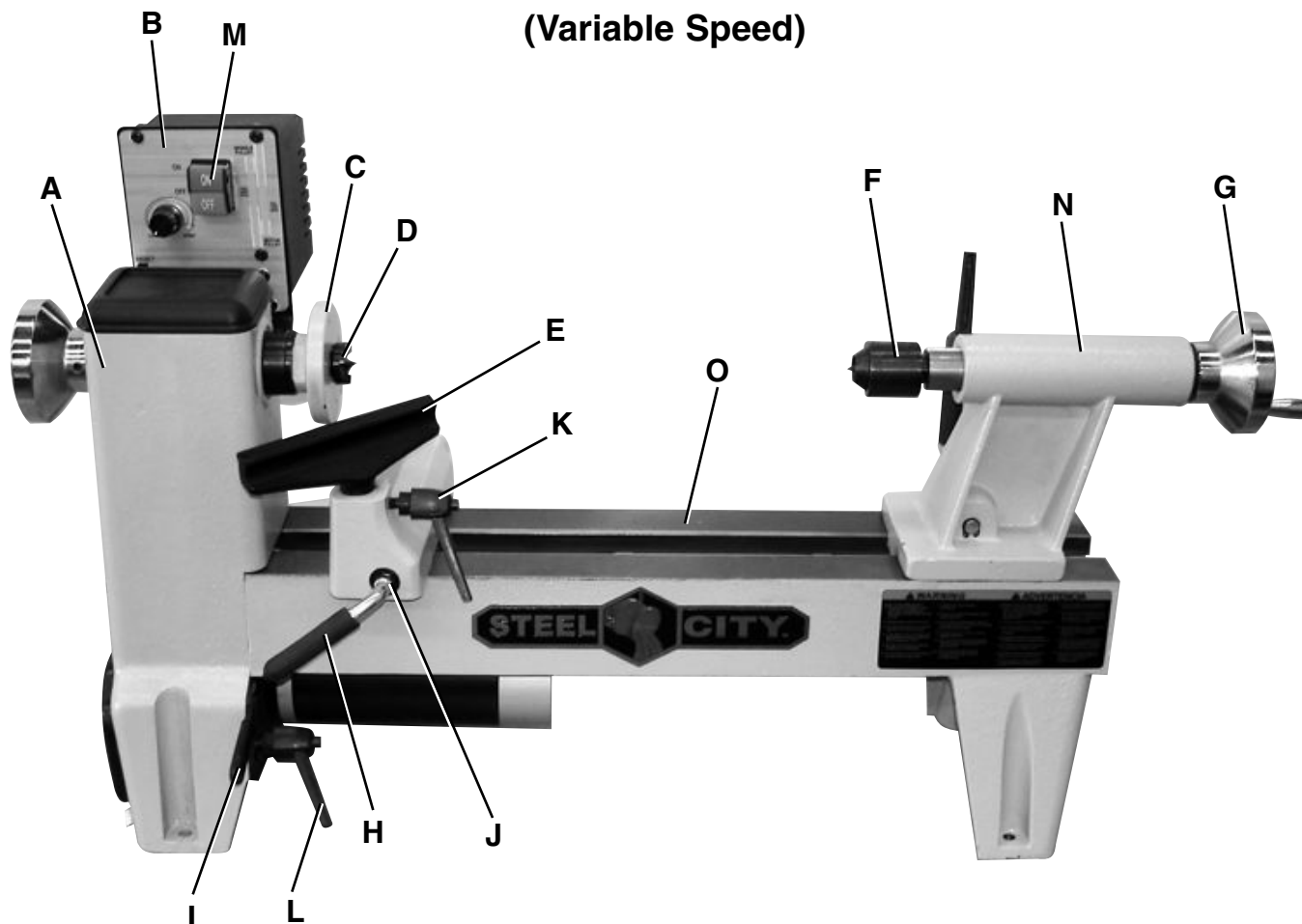
Headstock - The assembly fixed on the left-hand end of the bed of the lathe which provides the drive for the workpiece.

Tailstock - The movable assembly to the right of the headstock which slides along the bed.

Tool rest - Adjustable part of the lathe which fits into the banjo and supports the turning tool while the work is in progress.

FEATURE IDENTIFICATION

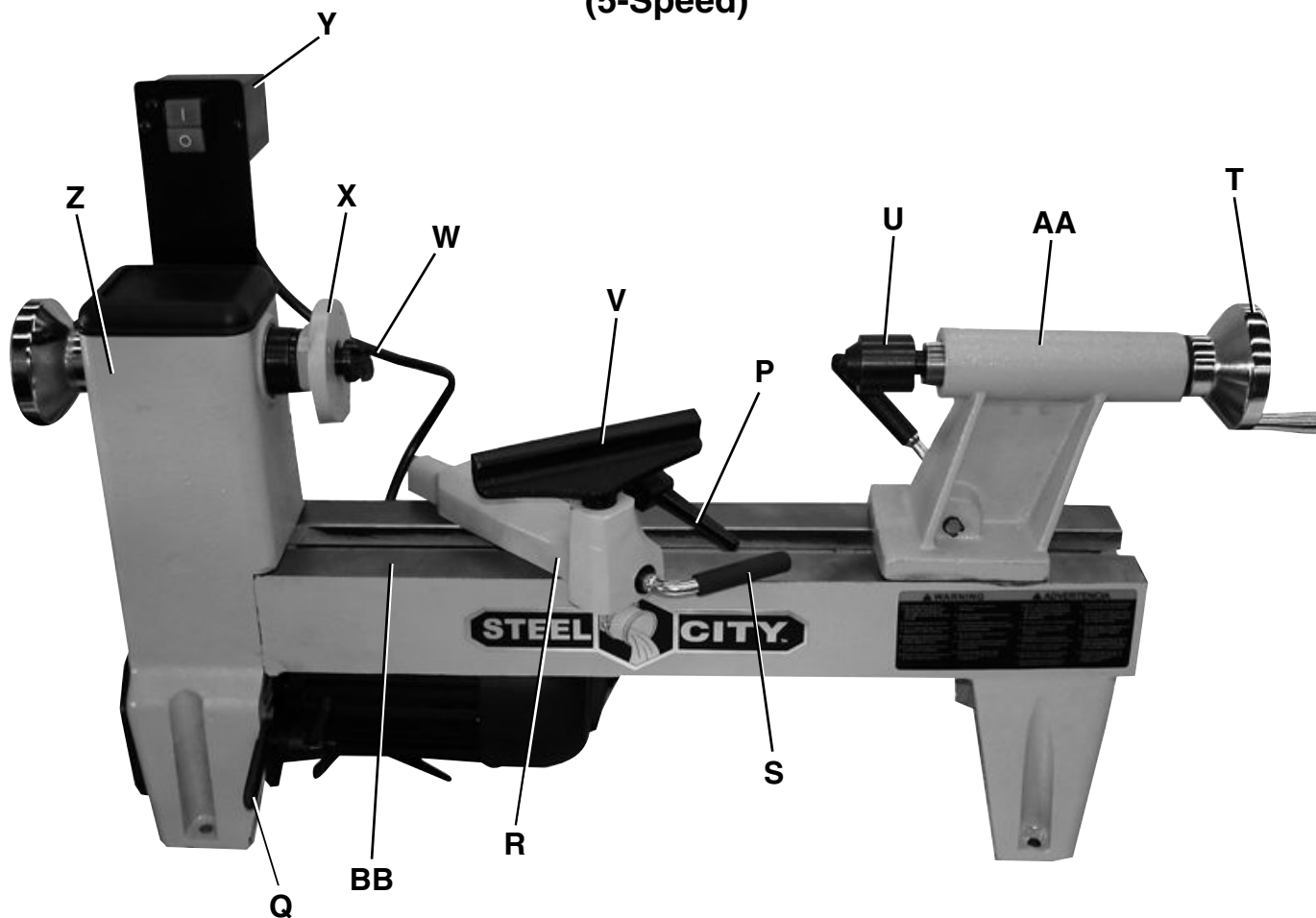
**Model Number 60100
(Variable Speed)**



- A) Headstock
- B) Variable Speed Switch
- C) Faceplate
- D) Drive center spindle
- E) Tool rest
- F) Tailstock spindle
- G) Handwheel
- H) Banjo lock handle
- I) Motor plate lever
- J) Banjo
- K) Tool rest lock handle
- L) Motor plate locking handle
- M) ON/OFF Switch
- N) Tailstock
- O) Bed

FEATURE IDENTIFICATION

Model Number 60170
(5-Speed)



- Z) Headstock
- Y) ON/OFF switch
- X) Faceplate
- W) Drive center spindle
- V) Tool rest
- U) Tailstock spindle
- T) Handwheel
- S) Banjo lock handle
- R) Banjo
- Q) Motor plate lever
- P) Tool rest lock handle
- AA) Tailstock
- BB) Bed

GENERAL SAFETY

WARNING

TO AVOID serious injury and damage to the machine, read and follow all Safety and Operating Instructions before assembling and operating this machine.

This manual is not totally comprehensive. It does not and can not convey every possible safety and operational problem which may arise while using this machine. The manual will cover many of the basic and specific safety procedures needed in an industrial environment.

All federal and state laws and any regulations having jurisdiction covering the safety requirements for use of this machine take precedence over the statements in this manual. Users of this machine must adhere to all such regulations.

Below is a list of symbols that are used to attract your attention to possible dangerous conditions.



This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

DANGER

Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.

WARNING

Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.

CAUTION

Indicates a potentially hazardous situation, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

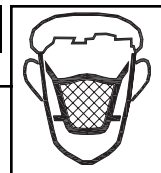
CAUTION

CAUTION used without the safety alert symbol indicates a potentially hazardous situation which, if not avoided, may result in property damage.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the machine.

WARNING



Exposure to the dust created by power sanding, sawing, grinding, drilling and other construction activities may cause serious and permanent respiratory or other injury, including silicosis (a serious lung disease), cancer, and death. Avoid breathing the dust, and avoid prolonged contact with dust. The dust may contain chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

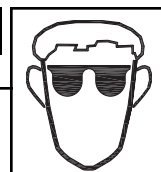
Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.

Always operate tool in well ventilated area and provide for proper dust removal. Use a dust collection system along with an air filtration system whenever possible. Always use properly fitting NIOSH/OSHA approved respiratory protection appropriate for the dust exposure, and wash exposed areas with soap and water.

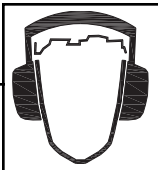
1. To avoid serious injury and damage to the machine, read the entire User Manual before assembly and operation of this machine.

WARNING



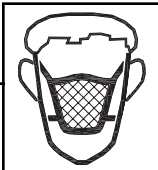
2. **ALWAYS** wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

⚠ WARNING



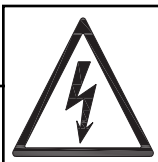
3. **ALWAYS** wear hearing protection. Plain cotton is not an acceptable protective device. Hearing equipment should comply with ANSI S3.19 Standards.

⚠ WARNING



4. **ALWAYS** wear a NIOSH/OSHA approved dust mask to prevent inhaling dangerous dust or airborne particles.
5. **ALWAYS** keep the work area clean, well lit, and organized. **DO NOT** work in an area that has slippery floor surfaces from debris, grease, and wax.
6. **ALWAYS** unplug the machine from the electrical receptacle when making adjustments, changing parts or performing any maintenance.
7. **AVOID ACCIDENTAL STARTING.** Make sure that the power switch is in the "OFF" position before plugging in the power cord to the electrical receptacle.

⚠ WARNING



8. **AVOID** a dangerous working environment. **DO NOT** use electrical tools in a damp environment or expose them to rain or moisture.

⚠ WARNING



9. **CHILDPROOF THE WORKSHOP AREA** by removing switch keys, unplugging tools from the electrical receptacles, and using padlocks.
10. **DO NOT** use electrical tools in the presence of flammable liquids or gasses.

11. **DO NOT FORCE** the machine to perform an operation for which it was not designed. It will do a safer and higher quality job by only performing operations for which the machine was intended.
12. **DO NOT** stand on a machine. Serious injury could result if it tips over or you accidentally contact any moving part.
13. **DO NOT** store anything above or near the machine.
14. **DO NOT** operate any machine or tool if under the influence of drugs, alcohol, or medication.
15. **EACH AND EVERY** time, check for damaged parts prior to using any machine. Carefully check all guards to see that they operate properly, are not damaged, and perform their intended functions. Check for alignment, binding or breakage of all moving parts. Any guard or other part that is damaged should be immediately repaired or replaced.
16. Ground all machines. If any machine is supplied with a 3-prong plug, it must be plugged into a 3-contact electrical receptacle. The third prong is used to ground the tool and provide protection against accidental electric shock. **DO NOT** remove the third prong.
17. Keep visitors and children away from any machine. **DO NOT** permit people to be in the immediate work area, especially when the machine is operating.
18. **KEEP** protective guards in place and in working order.
19. **MAINTAIN** your balance. **DO NOT** extend yourself over the tool. Wear oil resistant rubber soled shoes. Keep floor clear of debris, grease, and wax.
20. **MAINTAIN** all machines with care. **ALWAYS KEEP** machine clean and in good working order. **KEEP** all blades and tool bits sharp.
21. **NEVER** leave a machine running, unattended. Turn the power switch to the OFF position. **DO NOT** leave the machine until it has come to a complete stop.
22. **REMOVE ALL MAINTENANCE TOOLS** from the immediate area prior to turning the machine ON.
23. **SECURE** all work. When it is possible, use clamps or jigs to secure the workpiece. This is safer than attempting to hold the workpiece with your hands.
24. **STAY ALERT**, watch what you are doing, and use common sense when operating any machine. **DO NOT** operate any machine tool while tired or under the influence of drugs, alcohol, or medication. A moment of inattention while operating power tools may result in serious personal injury.

25. **USE ONLY** recommended accessories. Use of incorrect or improper accessories could cause serious injury to the operator and cause damage to the machine. If in doubt, **DO NOT** use it.
26. Wear proper clothing, **DO NOT** wear loose clothing, gloves, neckties, or jewelry. These items can get caught in the machine during operations and pull the operator into the moving parts. Users must wear a protective cover on their hair, if the hair is long, to prevent it from contacting any moving parts.
27. **SAVE** these instructions and refer to them frequently and use them to instruct other users.
28. Information regarding the safe and proper operation of this tool is also available from the following sources:

Power Tool Institute
1300 Summer Avenue
Cleveland, OH 44115-2851
www.powertoolinstitute.org

National Safety Council
1121 Spring Lake Drive
Itasca, IL 60143-3201

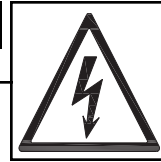
American National Standards Institute
25 West 43rd Street, 4th floor
New York, NY 10036
www.ansi.org

ANSI 01.1 Safety Requirements for
Woodworking Machines, and the U.S. Department
of Labor regulations
www.osha.gov

PRODUCT SAFETY

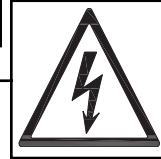
1. Serious personal injury may occur if normal safety precautions are overlooked or ignored. Accidents are frequently caused by lack of familiarity or failure to pay attention. Obtain advice from supervisor, instructor, or another qualified individual who is familiar with this machine and its operations.
2. Every work area is different. Always consider safety first, as it applies to your work area. Use this machine with respect and caution. Failure to do so could result in serious personal injury and damage to the machine.
3. Prevent electrical shock. Follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

WARNING



4. **TO REDUCE** the risk of electrical shock. **DO NOT** use this machine outdoors. **DO NOT** expose to rain or moisture. Store indoors in a dry area.
5. **STOP** using this machine, if at any time you experience difficulties in performing any operation. Contact your supervisor, instructor or machine service center immediately.
6. Safety decals are on this machine to warn and direct you to how to protect yourself or visitors from personal injury. These decals **MUST** be maintained so that they are legible. **REPLACE** decals that are not legible.
7. **DO NOT** leave the unit plugged into the electrical outlet. Unplug the unit from the outlet when not in use and before servicing, performing maintenance tasks, or cleaning.
8. **ALWAYS** turn the power switch "OFF" before unplugging the mini lathe.

WARNING



9. **DO NOT** handle the plug or mini lathe with wet hands.
10. **USE** accessories only recommended by Steel City.
11. **DO NOT** pull the mini lathe by the power cord. **NEVER** allow the power cord to come in contact with sharp edges, hot surfaces, oil or grease.
12. **DO NOT** unplug the mini lathe by pulling on the power cord. **ALWAYS** grasp the plug, not the cord.
13. **REPLACE** a damaged cord immediately. **DO NOT** use a damaged cord or plug. If the mini lathe is not operating properly, or has been damaged, left outdoors or has been in contact with water.
14. **DO NOT** use the mini lathe as a toy. **DO NOT** use near or around children.

15. **ALWAYS** rotate the workpiece by hand after installing on the faceplate.
16. **DO NOT** mount a split workpiece or one containing a knot.
17. **ALWAYS** use the lowest speed when starting a new workpiece.
18. **KEEP** guards in place and in working order.
19. **REMOVE** adjusting keys and wrenches. Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning it on.
20. **KEEP** the work area clean. Cluttered areas and benches invite accidents.
21. **DO NOT** use in a dangerous environment. Don't use power tools in damp or wet locations, or expose them to rain. Keep work area well lighted.
22. **KEEP** children away. All visitors should be kept a safe distance from the work area.
23. **MAKE** the workshop childproof with padlocks, master switches, or by removing starter keys.
24. **DO NOT** force the tool. It will do the job better and safer at the rate for which it was designed.
25. **WEAR** proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
26. **DO NOT** overreach. Keep proper footing and balance at all times.
27. **USE** the proper extension cord. Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will cause a drop in the line voltage resulting in loss of power and overheating.
28. **ALWAYS** use safety glasses. Also use face or dust masks if the cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are **NOT** safety glasses.
29. **MAINTAIN** tools with care. Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
30. **REDUCE** the risk of unintentional starting. Make sure the switch is in the OFF position before plugging in the machine.
31. **USE** recommended accessories. Consult the owner's manual for recommended accessories. The use of improper accessories may cause a risk of injury.
32. **CHECK** damaged parts. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
33. **DIRECTION OF FEED.** Feed work into a blade or cutter only against the direction of rotation of the blade or cutter.
34. **GIVE** your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.
35. **TURN OFF** the tool and disconnect from power before cleaning. Use a brush or compressed air to remove chips or debris - do not use your hands.
36. **NEVER** leave the tool running unattended. Turn the power off and do not leave the tool until it comes to a complete stop.

ELECTRICAL REQUIREMENTS

WARNING

TO PREVENT electrical shock, follow all electrical and safety codes, including the National Electrical Code (NEC) and the Occupational Safety and Health Regulations (OSHA). All electrical connections and wiring should be made by qualified personnel only.

TO REDUCE the risk of electrical shock, **DO NOT** use machine outdoors. **DO NOT** expose to rain. Store indoors in a dry area.

DO NOT connect the machine to the power source before you have completed the set up process. **DO NOT** connect the machine to the power source until instructed to do so.

The motor in this machine is designed to run at 115V.

GROUNDING INSTRUCTIONS

WARNING



This machine **MUST BE GROUNDED** while in use to protect the operator from electric shock.

In the event of a malfunction or breakdown, **GROUNDING** provides the path of least resistance for electric current and reduces the risk of electric shock. This machine is equipped with an electric cord that has an equipment-grounding conductor and a grounding plug. The plug **MUST** be plugged into a matching electrical receptacle that is properly installed and grounded in accordance with **ALL** local codes and ordinances.

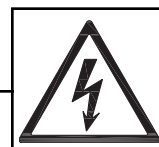
If a plug is provided with your machine **DO NOT** modify the plug. If it will not fit your electrical receptacle, have a qualified electrician install the proper connections to meet all electrical codes local and state. All connections must also adhere to all of OSHA mandates.

IMPROPER ELECTRICAL CONNECTION of the equipment-grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment-grounding conductor. **DO NOT** connect the equipment-grounding conductor to a live terminal if repair or replacement of the electric cord or plug is necessary.

Check with a qualified electrician or service personnel if you do not completely understand the grounding instructions, or if you are not sure the tool is properly grounded.

PLUGS/RECEPTACLES

WARNING



- Electrocution or fire could result if this machine is not grounded properly or if the electrical configuration does not comply with local and state electrical codes.
- **MAKE CERTAIN** the machine is disconnected from power source before starting any electrical work.
- **MAKE SURE** the circuit breaker does not exceed the rating of the plug and receptacle.

The motor supplied with your machine is a 115 volt motor. It is shipped wired for 115 volt application. Never connect the green or ground wire to a live terminal.

This tool is intended for use on a circuit that has an electrical receptacle as shown in Figure 1-1. Figure 1-1 shows a NEMA approved 3-wire, 15 amp electrical plug and receptacle that have a grounding conductor. If a properly grounded electrical receptacle is not available, an adapter as shown in Figure 1-2 can be used to temporarily connect this plug to a 2-contact ungrounded receptacle. The adapter has a rigid lug extending from it that **MUST** be connected to a permanent earth ground, such as a properly grounded receptacle box. **THIS ADAPTER IS PROHIBITED IN CANADA.**

Fig. 1-1

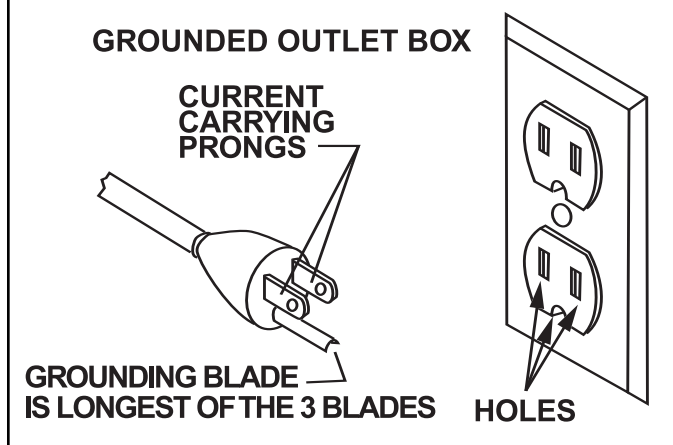
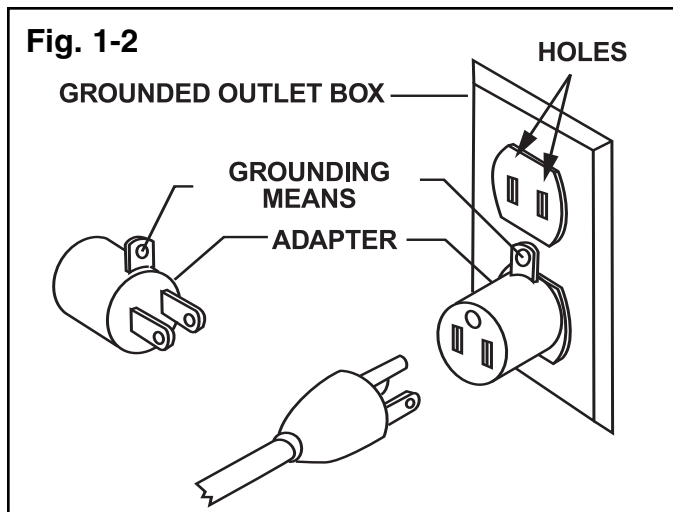
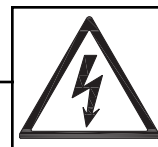


Fig. 1-2



EXTENSION CORDS

⚠ WARNING



To reduce the risk of fire or electrical shock, use the proper gauge of extension cord. When using an extension cord, be sure to use one heavy enough to carry the current your machine will draw.

The smaller the gauge-number, the larger the diameter of the extension cord is. If in doubt of the proper size of an extension cord, use a shorter and thicker cord. An undersized cord will cause a drop in line voltage resulting in a loss of power and overheating.

⚠ CAUTION

USE ONLY a 3-wire extension cord that has a 3-prong grounding plug and a 3-pole receptacle that accepts the machine's plug.

If you are using an extension cord outdoors, be sure it is marked with the suffix "W-A" ("W" in Canada) to indicate that it is acceptable for outdoor use.

Make certain the extension cord is properly sized, and in good electrical condition. Always replace a worn or damaged extension cord immediately or have it repaired by a qualified person before using it.

Protect your extension cords from sharp objects, excessive heat, and damp or wet areas.

MINIMUM RECOMMENDED GAUGE FOR EXTENSION CORDS (AWG)

115 VOLT OPERATION ONLY			
	25' LONG	50' LONG	100' LONG
0 to 6 Amps	18 AWG	16 AWG	16 AWG
6 to 10 Amps	18 AWG	16 AWG	Not recommended
10 to 12 Amps	16 AWG	16 AWG	Not recommended

UNPACKING & INVENTORY

Check shipping carton and machine for damage before unpacking. Carefully remove packaging materials, parts and machine from shipping carton. Always check for and remove protective shipping materials around motors and moving parts. Lay out all parts on a clean work surface.

Remove any protective materials and coatings from all of the parts and the mini lathe. The protective coatings can be removed by spraying WD-40 on them and wiping it off with a soft cloth. This may need to be redone several times before all of the protective coatings are removed completely.

After cleaning, apply a good quality paste wax to any unpainted surfaces. Make sure to buff out the wax before assembly.

Compare the items to inventory figures; verify that all items are accounted for before discarding the shipping box.

⚠ WARNING

If any parts are missing, do not attempt to plug in the power cord and turn "ON" the machine. The machine should only be turned "ON" after all the parts have been obtained and installed correctly. **For missing parts, contact Steel City at 1-877-SC4-TOOL.**

Model 60170



A) Lathe

B) Switch

C) Special wrench

D) Tool rest

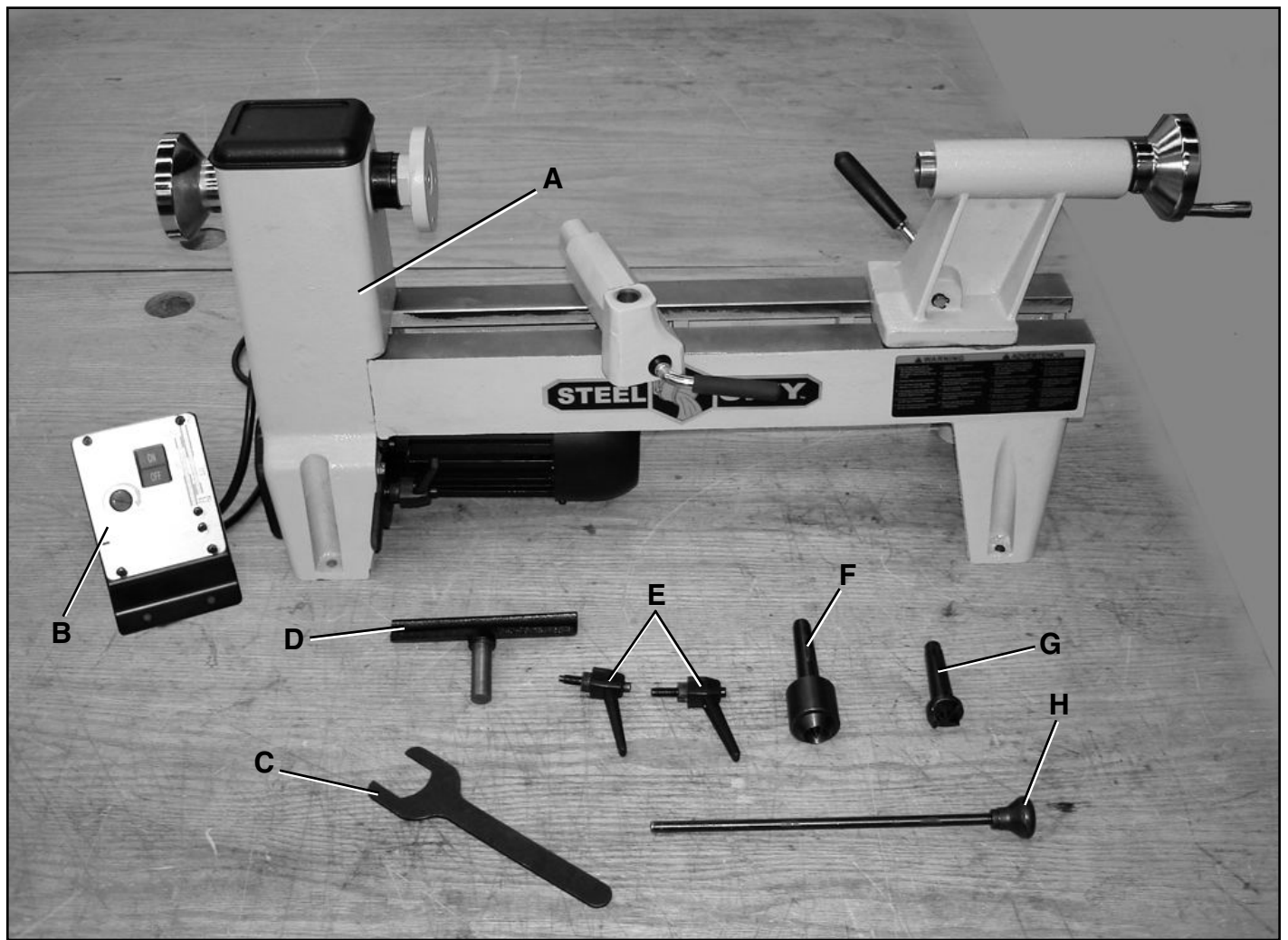
E) Lock handles (2)

F) Tailstock spindle

G) Drive center spindle

H) Knock-out rod

Model 60100



- A) Lathe
- B) Switch
- C) Special wrench
- D) Tool rest

- E) Lock handles (2)
- F) Tailstock spindle
- G) Drive center spindle
- H) Knock-out rod

ASSEMBLY

The Mini Lathe requires very little assembly as most components are already installed right out of the box.

SWITCH ASSEMBLY

The switch assembly must be mounted to the unit prior to operation of this machine.

To install:

1. Line up the two holes in the switch assembly with the two holes in the rear of the headstock
2. Fasten switch using the provided Phillips head screws and tighten securely. **SEE FIG 1.**

Fig. 1

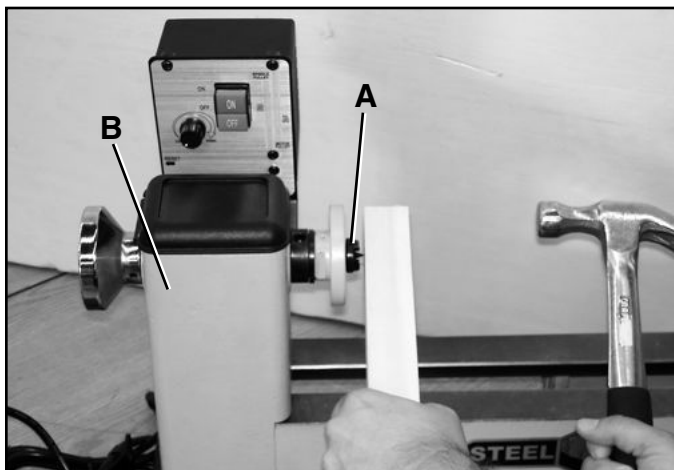


HEADSTOCK

The headstock is already installed. The only thing to install is the drive center spindle

1. Insert drive center spindle(A) into the hole in the headstock(B) **SEE FIG 1A.**
2. Using a hammer and a block of wood, tap the drive center to set it in the headstock.

Fig. 1A

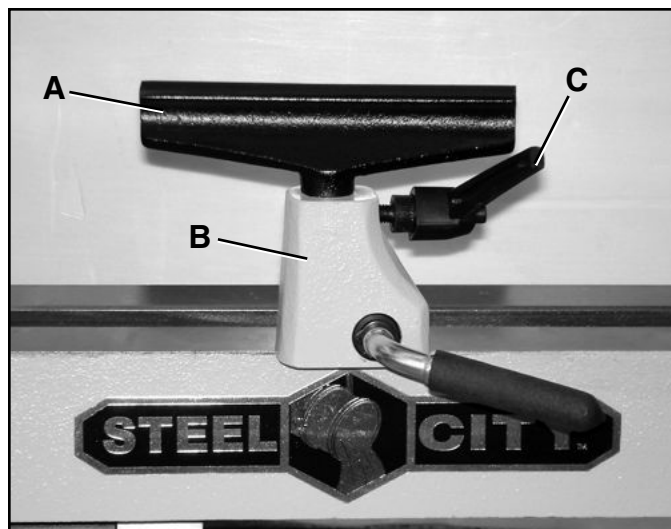


TOOL REST

1. Insert tool rest (A) into banjo (B). **SEE FIG 2.**
2. Thread lock handle (C) into banjo and tighten until the tool rest is secure.

NOTE: The lock handles are spring loaded and can be repositioned by pulling out on the handle, rotating and repositioning the handle. This allows for a greater range of motion when tightening or loosening.

Fig. 2

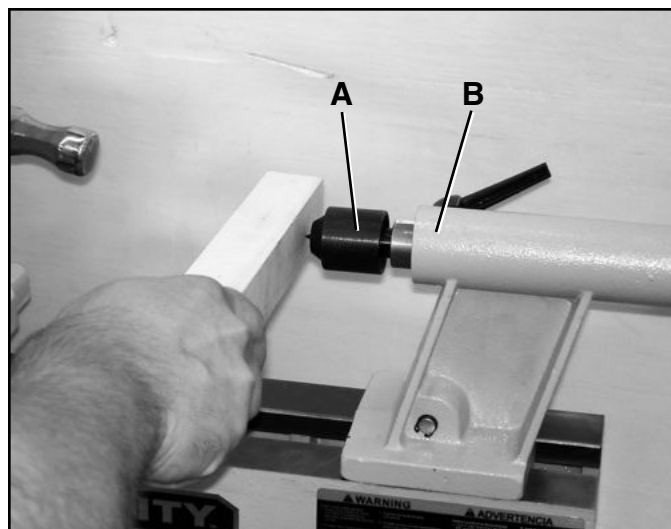


TAILSTOCK

While the tailstock is already installed on the machine, there are a few parts that need attached to it.

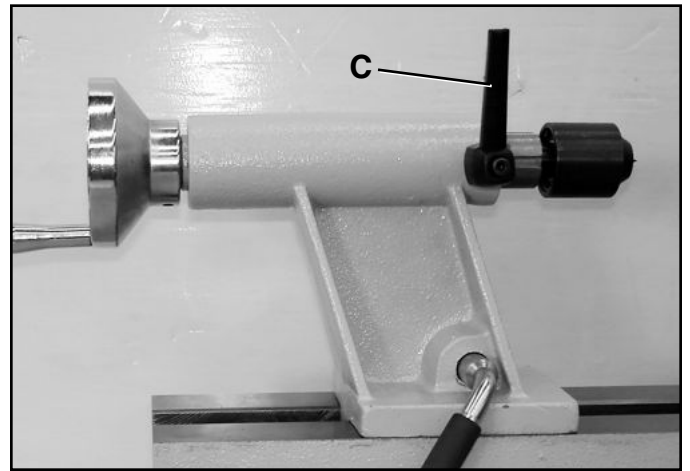
1. To install the tailstock spindle, insert spindle (A) through the hole in the tailstock (B). **SEE FIG 3.**

Fig. 3



- Using a hammer and a block of wood, tap the tailstock spindle to set it in the tailstock.
- Thread lock handle (C) into the tailstock and tighten. **SEE FIG 4.**

Fig. 4



ADJUSTMENTS

ADJUSTING THE TOOL REST

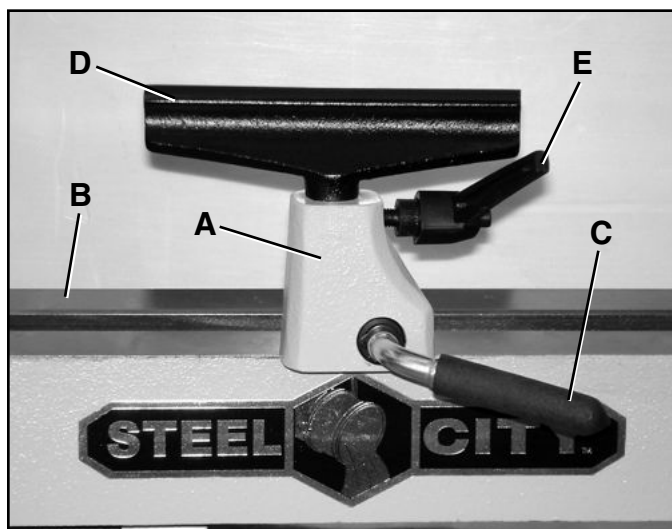
The tool rest should be positioned as close as possible to the workpiece. It should be 1/8" below the centerline of the workpiece. Rotate the workpiece by hand to make certain you have proper clearance.

⚠ WARNING

MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

- Position the banjo (A) on the bed (B) by loosening the banjo lock handle (C) and sliding the banjo to the desired position. Tighten handle to lock. **SEE FIG 5.**
- Adjust the height of the tool rest (D) by loosening the tool rest lock handle (E) and raising or lowering the tool rest.

Fig. 5



- If the banjo will not tighten securely using the banjo lock handle, see **ADJUSTING CLAMPING PRESSURE**.

ADJUSTING CLAMPING PRESSURE

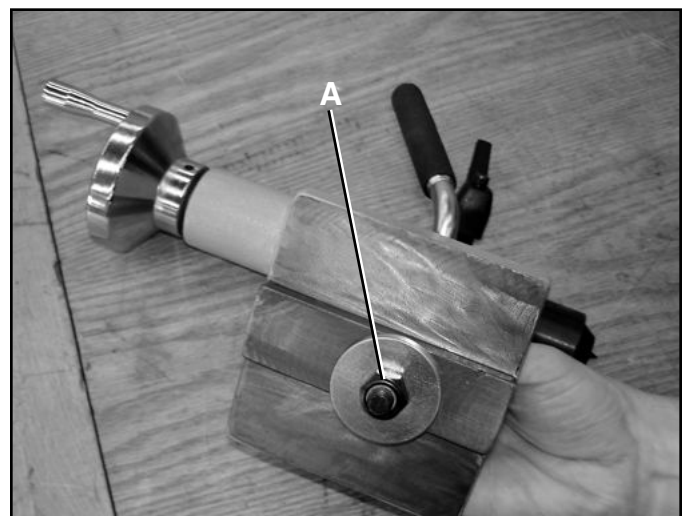
The clamping device on the banjo and tailstock are set at the factory and should not need adjustment; however, if further adjustment should be needed:

⚠ WARNING

MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

- Slide the tailstock and/or banjo off the end of the bed.
- Tighten or loosen nut (A) beneath the tailstock and/or banjo. **SEE FIG 6.**

Fig. 6



3. Replace tailstock and/or banjo and recheck clamping pressure. If further adjustment is necessary, repeat steps 1 and 2.

REMOVING SPINDLES

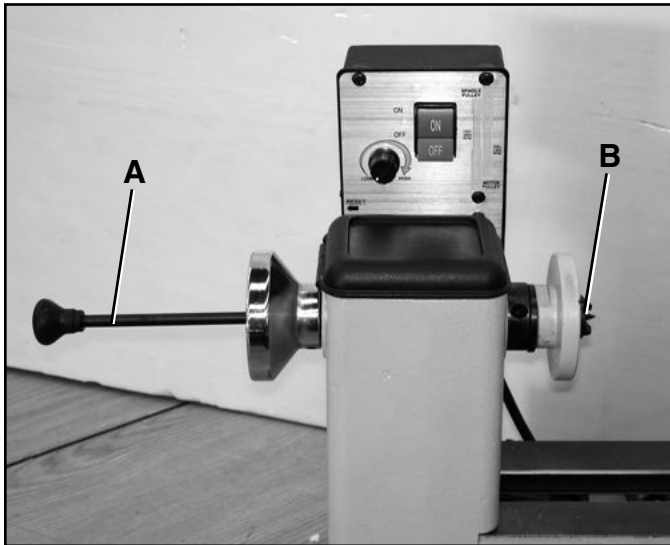
A knockout rod is provided to remove either the drive center spindle from the headstock or the tailstock spindle from the tailstock.

⚠ WARNING

MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

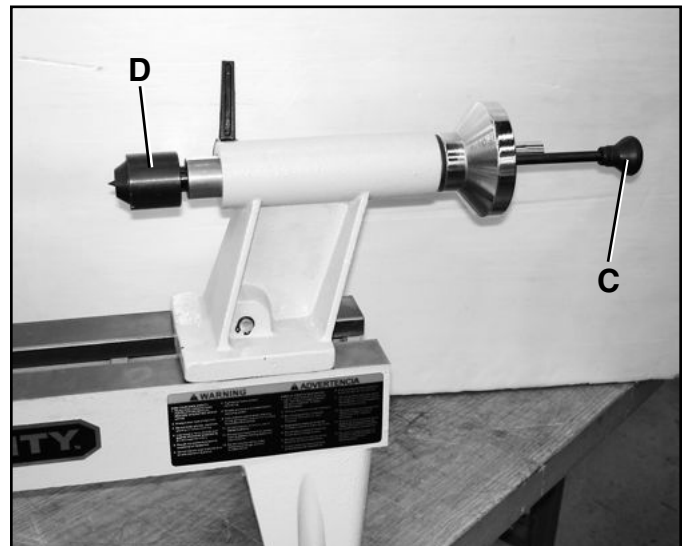
1. To remove spindle from the headstock, slide the knockout rod (A) into the hole in the headstock. **SEE FIG 7.**

Fig. 7



2. Put your right hand on the drive center spindle (B) and prepare to catch it as it comes out of the headstock.
3. Using your left hand, tap the knockout rod, and catch the spindle with your right hand as it comes out of the headstock. Take care not to let the spindle hit the ground to help prevent damage to the tip.
4. To remove the spindle from the tailstock, slide the knockout rod (C) into the hole in the tailstock. **SEE FIG 8.**
5. Place your left hand on the tailstock spindle (D) and prepare to catch it as it comes out of the tailstock.
6. Using your right hand, tap the knockout rod and catch the spindle with your left hand as it comes out of the tailstock. Take care not to let the spindle hit the floor to help prevent damage to the spindle.

Fig. 8



FACE PLATE

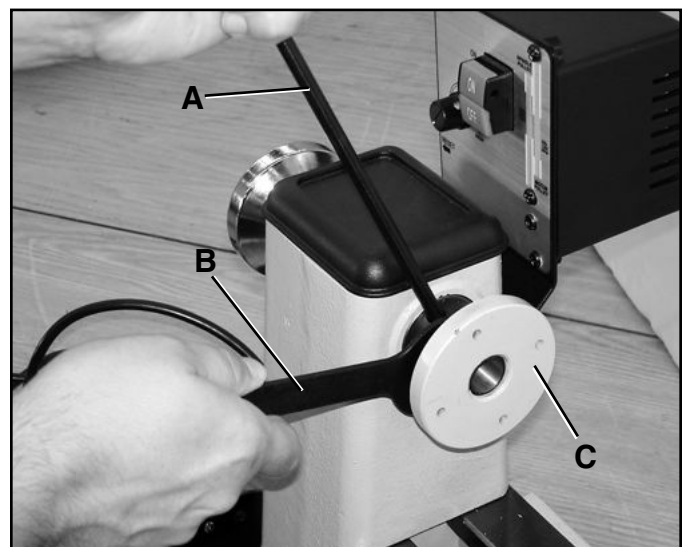
The face plate screws to the headstock and is used in face turning operations. To remove the faceplate:

⚠ WARNING

MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

1. Place Knockout rod (A) in one of the holes provided in the headstock. **SEE FIG 9.**

Fig. 9



2. Place wrench (B) on the flats of the inside of the faceplate (C).
3. Turn wrench counterclockwise to loosen the faceplate and remove.

CHANGING SPINDLE SPEEDS (MODEL 60170 ONLY)

THIS SECTION ONLY APPLIES TO THE 5 SPEED MINI LATHE, MODEL 60170. FOR INFORMATION ON CHANGING SPEEDS ON THE VARIABLE SPEED MINI LATHE, MODEL 60100, REFER TO THE CHANGING SPINDLE SPEEDS SECTION THAT FOLLOWS THIS SECTION.

⚠ WARNING

MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

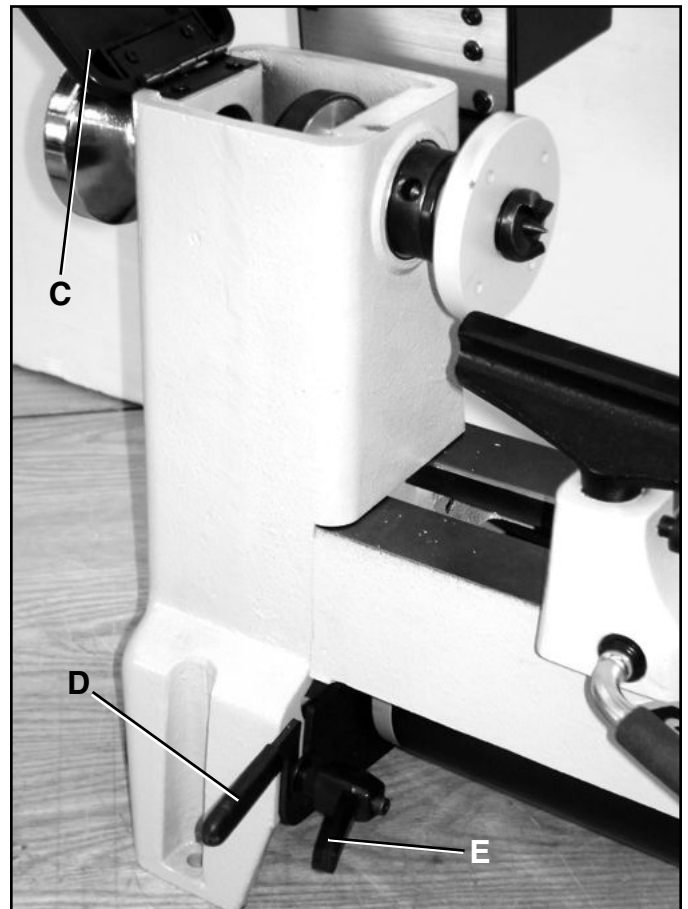
1. Open the lower access door (A) on the left side of the base and the upper access door (C) on the top of the headstock to expose the pulleys. **SEE FIGS. 10 and 11.**

Fig. 10



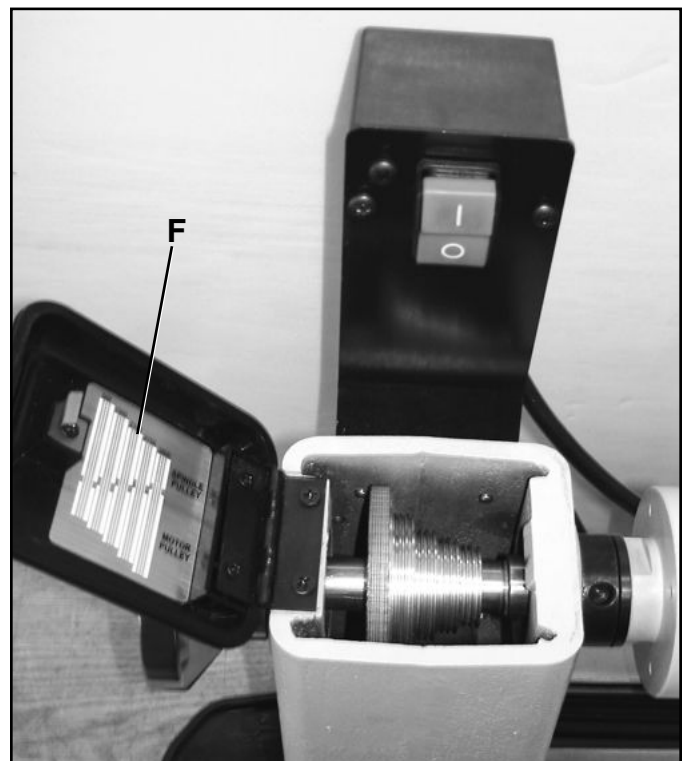
2. Loosen the motor plate lock handle (E) and lift up on the motor plate lever (D) to take the tension off of the belt.
3. Move the belt (B) to the desired pulley groove according to the speed chart (F) on the inside of the upper access door. Be sure that the belt is aligned with the spindle pulley and the motor pulley. **SEE FIGS. 10 AND 12.**

Fig. 11



4. Tension the belt by pushing down on the motor plate lever (D) and retightening the motor plate lock handle (E).

Fig. 12



CHANGING SPINDLE SPEEDS (MODEL 60100 ONLY)

THIS SECTION ONLY APPLIES TO THE VARIABLE SPEED MINI LATHE, MODEL 60100. FOR INFORMATION ON CHANGING SPEEDS ON THE 5 SPEED MINI LATHE, MODEL 60170, REFER TO THE CHANGING SPINDLE SPEEDS SECTION THAT PRECEDES THIS SECTION.

The variable speeds of the lathe are controlled by the speed knob on the variable speed control switch, as well as the position of the belt on the pulleys. The speed ranges for the pulley are marked on the control switch. Determine which speed range you wish to work in before adjusting the spindle speed.

⚠ WARNING

MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

1. Open the lower access door (A) on the left side of the base and the upper access door (C) on the top of the headstock to expose the pulleys. **SEE FIGS. 13 and 14.**

Fig. 13



2. Loosen the motor plate lock handle (E) and lift up on the motor plate lever (D) to take tension off of the belt. **SEE FIG. 11, page 22.**
3. Refer to the chart on the variable speed control switch and move the belt (B) to the desired pulley groove. Make certain that the belt is aligned with the motor pulley and the spindle pulley. **SEE FIG. 14.**
4. Tension the belt by pushing down on the motor plate lever and lock in place with the motor plate lock handle.

Fig. 14



VARIABLE SPEED CONTROL (MODEL 60100 ONLY)

THIS SECTION APPLIES ONLY TO THE VARIABLE SPEED MINI LATHE, MODEL NUMBER 60100. IF THIS IS NOT YOUR MODEL, YOU MAY SKIP THIS SECTION.

⚠ WARNING

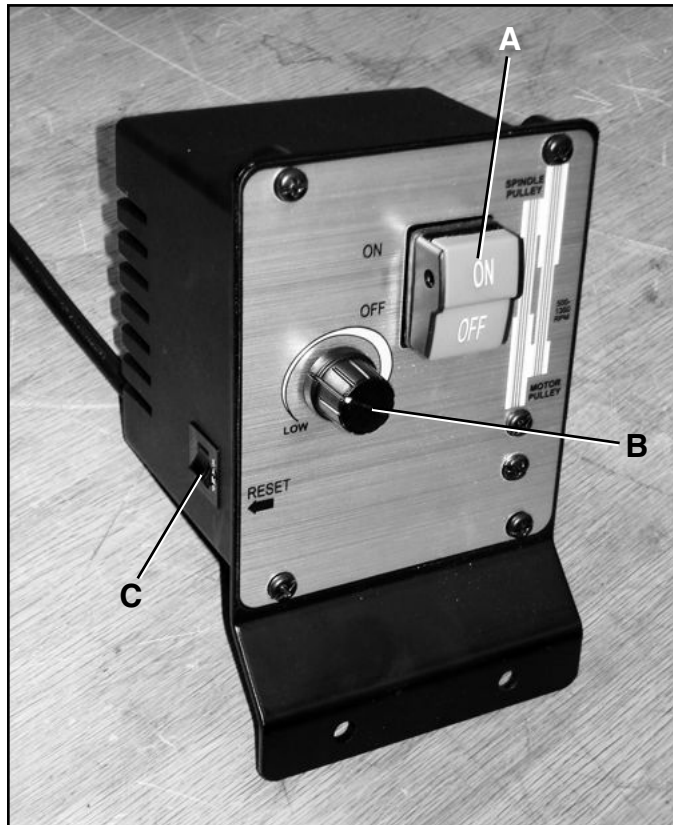
Always set the speed control knob to its lowest setting before starting the machine. NEVER start a workpiece at maximum speed

The variable speed control switch contains the electrical connections to the motor and has three external controls. They are as follows

1. ON/OFF Switch.
2. Speed Control Knob
3. Thermal Reset Button

The ON/OFF (A) switch controls electrical power to the lathe motor. The lathe will begin turning when the ON button is pressed. It will take up to 3 seconds before the lathe comes up to full speed. The time at which the lathe comes up to full speed is determined by the size and weight of the workpiece. To turn the motor off, push the OFF button and wait for the unit to come to a complete stop. **SEE FIG. 15, page 24.**

Fig. 15



The Speed Control Knob(B) sets the speed of the lathe to suit the weight of the workpiece or the type of tool being used. After the lathe is started, turn the knob clockwise to increase the speed , turn counterclockwise to reduce the speed.

NOTE: The variable speed knob is not the only determine of the speed of the spindle. The spindle speed also is determined by the setting of the pulleys. For more information on the pulley settings, refer to **CHANGING SPINDLE SPEEDS (MODEL 60100 ONLY)** in the **ADJUSTMENTS** section of this manual.

The Thermal Reset Button (C) provides 8-amp overload protection. If the lathe stops suddenly during operation or does not start when the ON button is pushed, an overload condition may have occurred. In this case:

1. Press the OFF button.
2. Press the Thermal Reset Button.
3. Restart the lathe by pressing the ON button.

FASTENING LATHE TO SUPPORTING SURFACE

If during operation there is any tendency for the lathe to tip over, slide, or walk on the supporting surface, the base of the lathe must be secured to the supporting surface with fasteners (not supplied) through the four holes located in the feet of the lathe.

OPERATIONS

TRIAL RUN

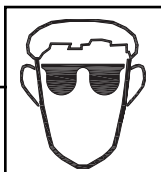
Once all of the lathe has been assembled and all of the adjustments have been made, its time for a trial run.

1. Turn variable Speed knob to it's lowest setting. (This applies to Model 60100 only. Model 60170 Owners can skip this step.)
2. Press the ON button. Keep your hand near the switch, ready to shut the machine down in case anything does not sound right or if there appears to be a problem.
3. The lathe should run smoothly with little to no vibration. If any strange noises or loose parts are noticed, shut the machine down and recheck all adjustments.
4. If everything seems to be in order, you are now ready to turn some wood.

NOTICE: The following section is designed to give instructions on the basic operations of this lathe. It is in no way comprehensive of every lathe operation. It is **STRONGLY** recommended that you read books, trade magazines, or get formal training to maximize the potential of your lathe and to minimize the risks.

TURNING BETWEEN CENTERS

WARNING



ALWAYS wear eye protection. Any machine can throw debris into the eyes during operations, which could cause severe and permanent eye damage. Everyday eyeglasses are **NOT** safety glasses. **ALWAYS** wear Safety Goggles (that comply with ANSI standard Z87.1) when operating power tools.

It is always a good idea to start with a small workpiece to get used to the feel of the lathe. Once you select your workpiece:

1. Using a straight edge, draw an X from corner to corner, where the center of your X is the center of the workpiece.
2. Place your workpiece between the Headstock Drive Center Spindle and the Tailstock Spindle, making sure that the centers that you marked in Step 1 go into the centers of their respective spindles.
3. Lock down the tailstock assembly using the lever, then crank the handwheel clockwise until the workpiece is held firmly in place.
4. Position the tool rest so that it sits 1/8" away from the edge of the workpiece. Rotate the workpiece by hand to make sure that it does not come in contact with the tool rest
5. Turn the lathe ON. When first starting out, make sure that lathe is set to run at its slowest speed. As you become more comfortable and gain experience with the lathe, you may increase the speed of the spindle.
6. When cutting, the object is to cut the outer layer of the workpiece to a designed depth then hold the cutting tool steady with the beveled edge parallel to the outer edge of the workpiece. The way to hold the cutting tool steady is to rest it on the tool rest. **NEVER** perform freehand operations without the tool rest as serious injury can occur.

WARNING

Proper tool rest placement is **ESSENTIAL** to good results and **CRITICAL** for safety. A tool rest that is positioned too low will result in too much bite which will make the cutting tool very difficult to handle. A tool rest that is positioned too high can result in a dangerous kickback. If the tool rest is too far away from the workpiece, it will be difficult to hold the cutting tool because of reduced leverage. Remember as a general rule to **ALWAYS** keep the tool rest positioned 1/8" away from the outermost edge of the workpiece.

FACEPLATE TURNING

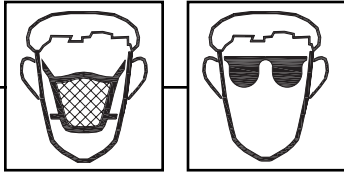
Faceplate turning is primarily used in the turning of bowls or bowl shaped items.

1. Remove as much excess material from the inside and outside of the workpiece before attaching to the lathe
2. The workpiece should be fastened to the faceplate using wood screws(not included). Make certain that the screws drive in about halfway through the bottom of the workpiece.
3. Position the tool rest so that you can shape the outside of the workpiece first.
4. Once outside work has been completed, disconnect the machine from the power source and reposition the tool rest so that is opposite the face of the workpiece.
5. Reconnect power supply, turn the machine on, and proceed to hollow out the workpiece.

MAINTENANCE

CLEANING

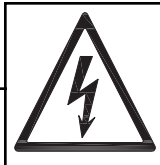
⚠ WARNING



With the machine unplugged, blow off motor with low pressure air to remove dust or dirt. Air pressure above 50 P.S.I. should not be used as high-pressure air may damage insulation. The operator should always wear a respirator and eye protection when using compressed air.

Do not allow chips and dust to accumulate under lathe. Keep area clean and in safe order.

⚠ WARNING



Turn the power switch "OFF" and unplug the power cord from its power source prior to any maintenance.

LUBRICATION

Occasionally, moving parts should be lubricated with a good quality machine oil.

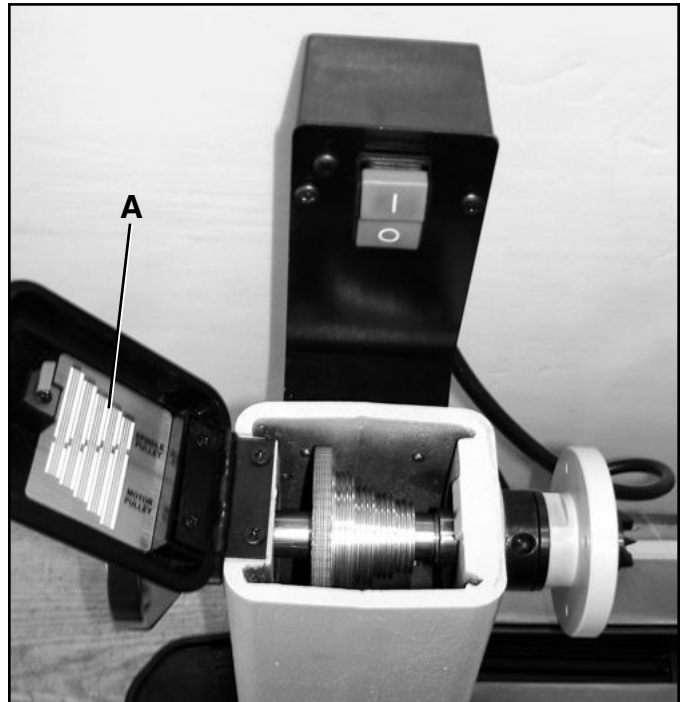
A coat of paste wax should be applied to the bed of the lathe to help keep the surface clean and to ease the movement of the banjo and the tailstock.

BELT REPLACEMENT

⚠ WARNING

MAKE CERTAIN THAT THE MACHINE IS DISCONNECTED FROM THE POWER SOURCE.

Fig. 16



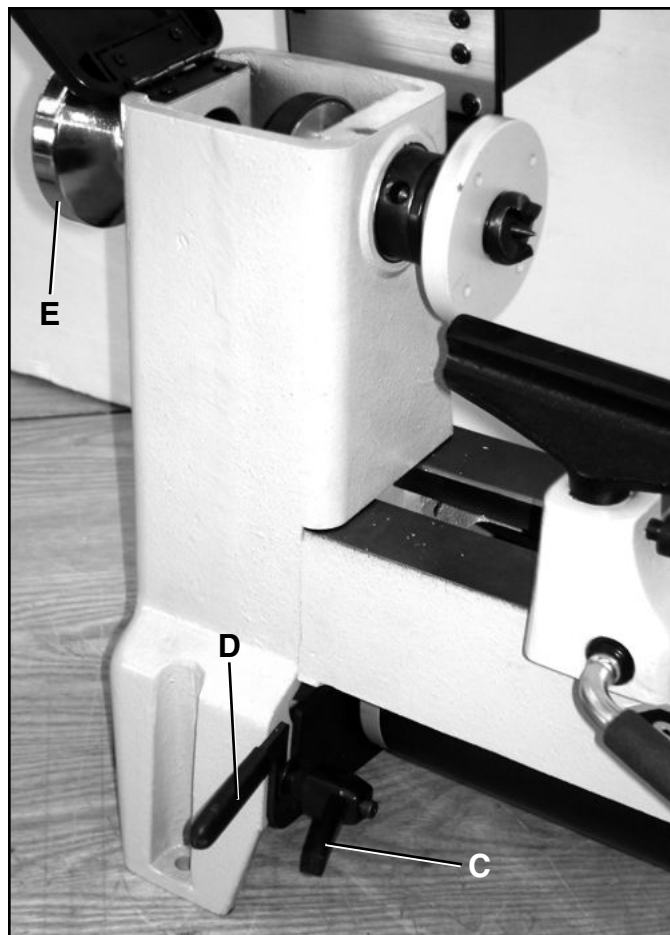
1. Open the upper access door (A) at the top of the headstock and the lower access door (B) at the left side of the base. **SEE FIGS 16 and 17.**

Fig. 17



2. Loosen the motor plate lock handle (C) and lift up on the motor plate handle (D) to take tension off of the belt. **SEE FIG 18.**
3. Locate the set screw on the spindle pulley and loosen the set screw.
4. Loosen the two set screws in the handwheel (E)
5. Remove the handwheel and pull out the spindle while holding onto the spindle pulley
6. Place the new belt on the spindle pulley and put the spindle pulley back in place the same way it was removed.
7. Insert the spindle into the spindle pulley, making sure to align the key.
8. Thread the handwheel onto the spindle leaving a little space between the handwheel and the headstock and tighten the set screws.
9. Center the spindle pulley and tighten the set screw
10. Wrap the belt around the motor pulley making sure that the belt is aligned with the spindle pulley and the motor pulley.
11. Tension the belt using the motor plate handle and lock in place with the motor plate lock handle.

Fig. 18



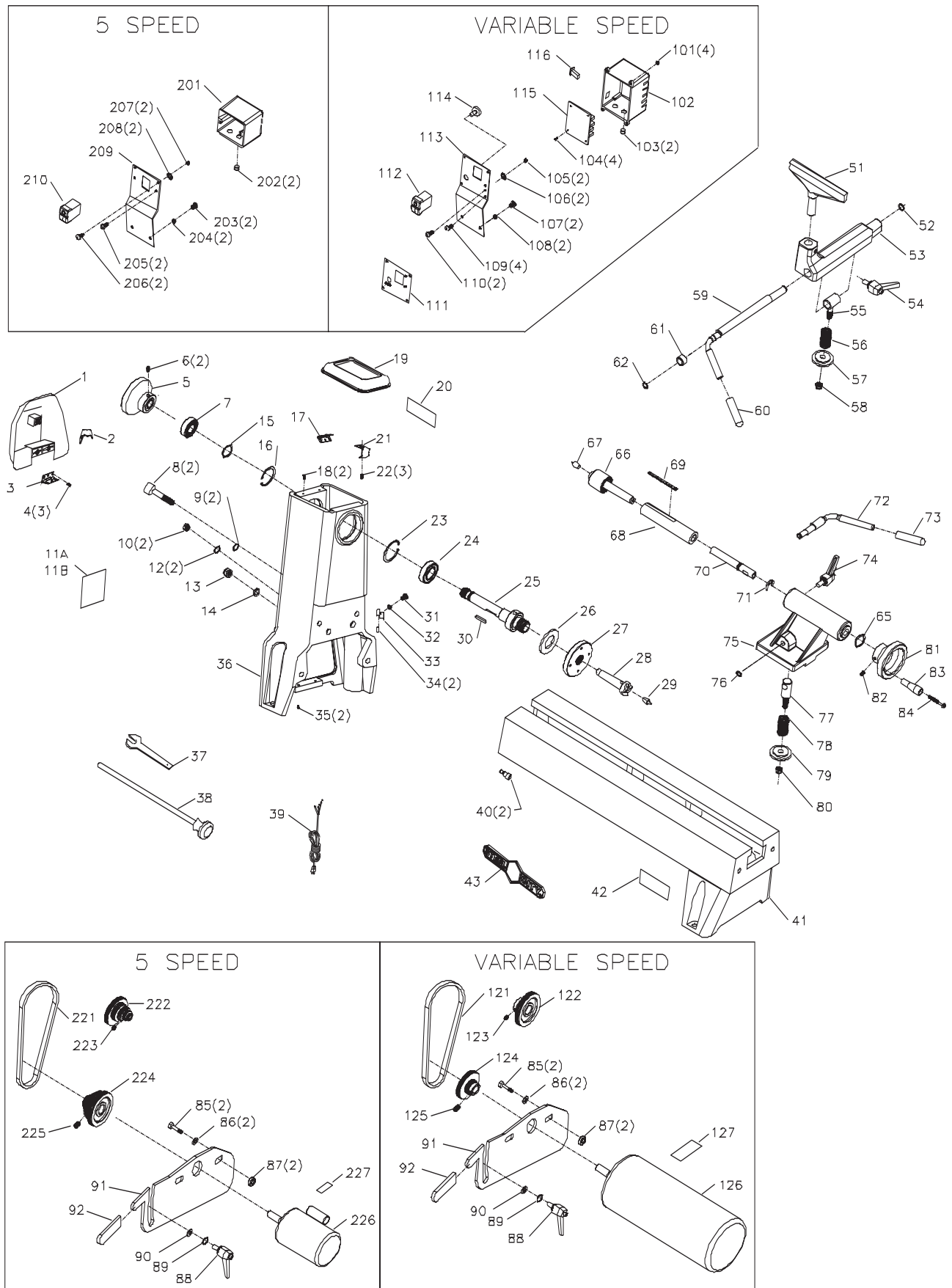
TROUBLESHOOTING GUIDE

TO PREVENT INJURY TO YOURSELF or damage to the lathe, turn the switch to the OFF position and unplug the power cord from the electrical receptacle before making any adjustments.

PROBLEM	LIKELY CAUSE(S)	SOLUTION
Excessive vibration.	<ol style="list-style-type: none"> 1. Workpiece warped, out of round, has major flaw, improperly prepared for turning, or RPM is set too high. 2. Worn spindle bearings. 3. Worn belt. 4. Motor mount bolts loose. 5. Lathe on uneven surface. 	<ol style="list-style-type: none"> 1. Correct problem by planing, bandsawing, reduce the RPM, or scrap workpiece all together. 2. Replace bearings. 3. Replace belt. 4. Tighten bolts. 5. Move to a different surface or bolt to a workbench or stand.
Motor or spindle stalls or will not start.	<ol style="list-style-type: none"> 1. Excessive cut. 2. Defective motor. 3. Broken belt. 4. Worn spindle bearings. 5. Capacitor is bad (Model 60170 only) 6. Brushes are bad (Model 60100 only) 	<ol style="list-style-type: none"> 1. Reduce cut depth. 2. Replace motor. 3. Replace belt. 4. Replace bearings. 5. Replace the capacitor (Model 60170 only). 6. Replace brushes (Model 60100 only).
Motor fails to develop full power.	<ol style="list-style-type: none"> 1. Power line overloaded. 2. Undersize wires in supply system, or extension cord is too long. 3. Low voltage. 4. Capacitor is bad (Model 60170 only). 5. Defective motor. 	<ol style="list-style-type: none"> 1. Correct overload condition. 2. Increase supply wire size. 3. Request voltage check from power company and correct low voltage condition. 4. Replace capacitor (Model 60170 only). 5. Replace motor.
Tools tend to grab or dig in.	<ol style="list-style-type: none"> 1. Dull tools. 2. Tool support set too low. 3. Tool support set too far from workpiece. 4. Improper tool being used. 	<ol style="list-style-type: none"> 1. Sharpen tools. 2. Reposition tool support height. 3. Reposition tool support closer to workpiece. 4. Use correct tool for operation.
Tailstock moves when applying pressure.	<ol style="list-style-type: none"> 1. Tailstock clamping device not adjusted properly. 2. Lathe bed and tailstock mating surfaces are greasy or oily. 	<ol style="list-style-type: none"> 1. Tighten nut beneath the tailstock. 2. Remove and clean surfaces with a cleaner degreaser.

◆ NOTES ◆

PARTS



KEY NO.	PART NO.	DESCRIPTION	QTY.	KEY NO.	PART NO.	DESCRIPTION	QTY.
1	OR71600	SIDE COVER	1	73	OR71637	HANDLE SLEEVE	1
2	OR71601	SPRING CLAMP	1	74	OR71624	HANDLE ASSY	1
3	OR71602	HINGE	1	75	OR71664	TAIL STOCK	1
4	OR94190	ST3.5X9.2 FL HD TAP SCREW	3	76	OR94200	EXT RET RING	1
5	OR71603	HEAD STOCK HANDWHEEL, INCL REF 6	1	77	OR71665	SCR SHAFT	1
6	OR90222	M6x10MM HEX SOC SET SCREW	2	78	OR71626	COMPRESSION SPRING	1
7	OR94191	BEARING 6004-2RS	1	79	OR71627	CLAMP PLATE	1
8	OR93381	M8x20MM HEX SOC HD SCREW	2	80	OR90927	M10 LOCK NUT	1
9	OR90248	LOCK WASHER M8	2	81	OR71638	HAND WHEEL, INCL REF 82	1
10	OR90239	M6 NUT	2	82	OR90222	M6x10MM HEX SOC SET SCREW	1
11A	OR70325	SPEC LABEL (VARIABLE SPEED)	1	83	OR71639	HANDLE	1
11B	OR70326	SPEC LABEL (5 SPEED)	1	84	OR94201	M6x55MM SHOULDER SCREW	1
12	OR90502	LOCK WASHER M6	2	85	OR90508	M6X20 HEX HD SCREW	2
13	OR92724	M8 LOCK NUT	1	86	OR90502	LOCK WASHER M6	2
14	OR90311	WASHER M8	1	87	OR71640	SLEEVE	2
15	OR94192	WAVE WASHER	1	88	OR71624	HANDLE ASSY	1
16	OR94193	INT RET RING	1	89	OR90311	FLAT WASHER M8	1
17	OR71602	HINGE	1	90	OR90248	LOCK WASHER M8	1
18	OR93987	M5x10MM FL HD SCREW	2	91	OR71641	ADJUSTING BRACKET, INCL REF 92	1
19	OR71604	HEADSTOCK COVER	1	92	OR71642	HANDLE SLEEVE	1
20	OR71605	ADJUST LABEL (5 SPEED)	1	100	OR71643	VARIABLE SPEED SWITCH ASSY, CONST OF REF 101,102,103,104,105,106, 107,108,109,110,111,112,113,114,115,116	1
21	OR71601	SPRING CLAMP	1				
22	OR94190	ST3.5x9.2MM FLAT HD TAP SCREW	3	101	OR94202	M5 NUT	4
23	OR94194	INT RET RING	1	102	OR71644	ELECTRIC-BOX	1
24	OR94195	BEARING 6005-2RS	1	103	OR94203	STRAIN RELIFE(6P-4)	2
25	OR71606	SPINDLE SHAFT	1	104	OR94204	ST2.9X16MM PAN HD TAP SCREW	4
26	OR71607	WASHER	1	105	OR90381	M5 HEX NUT	2
27	OR71608	FACE PLATE	1	106	OR90362	5.3MM EXT TOOTH WASHER	2
28	OR71609	DRIVING CENTER	1	107	OR90306	M6x12MM PAN HD SCREW	2
29	OR71610	CENTER POINT	1	108	OR90502	LOCK WASHER M6	2
30	OR94196	KEY A5x28	1	109	OR90761	M5x10MM PAN HD SCREW	4
31	OR90306	M6x12MM PAN HD SCREW	1	110	OR90761	M5x10MM CHEESE HD SCREW	2
32	OR90502	LOCK WASHER M6	1	111	OR71645	DIRECTION CHART	1
33	OR71611	WIRE CLAMP	1	112	OR71646	SWITCH	1
34	OR71612	WIRE JACKET	2	113	OR71647	ELECTRIC-BOX-BRACKET	1
35	OR90761	M5x10MM PAN HD SCREW	2	114	OR71648	SPEED ADJUSTMENT KNOB	1
36	OR71613	HEAD STOCK	1	115	OR71649	CIRCUIT BOARD	1
37	OR71614	SPINDLE WRENCH	1	116	OR71650	RESET SWITCH	1
38	OR71615	KNOCK OUT BAR	1	121	OR71651	BELT	1
39	OR71616	POWER CORD	1	122	OR71652	SPINDLE PULLEY, INCL REF 123	1
40	OR71617	PIN	2	123	OR90222	M6x10MM HEX SOC SET SCREW	1
41	OR71618	BED, INCL REF 42, 43	1	124	OR71653	MOTOR PULLEY, INCL REF 125	1
42	OR71619	WARNING LABEL	1	125	OR90222	M6x10MM HEX SOC SET SCREW	1
43	OR71620	NAMEPLATE	1	126	OR70430	MOTOR,INCL, REF 127 (VARIABLE SPEED)	1
50	OR71621	TOOL REST ASSY, CONST OF REF 51,52,53,54,55,56,57,58,59,60,61,62		127	OR70377	MOTOR LABEL (VARIABLE SPEED)	1
51	OR71622	TOOL REST	1	200	OR71654	5-SPEED SWITCH ASSY CONST OF REF 201,202,203,204,205,206,207,208,209,210	1
52	OR94197	EXT RET RING	1	201	OR71655	ELECTRIC-BOX	1
53	OR71623	TOOL REST BASE	1	202	OR94205	STRAIN RELIEF	2
54	OR71624	HANDLE ASSY	1	203	OR90306	M6x12MM PAN HD SCREW	2
55	OR71625	EYE BOLT	1	204	OR90502	LOCK WASHER M6	2
56	OR71626	COMPRESSION SPRING	1	205	OR90761	M5x10MM CHEESE HD SCREW	4
57	OR71627	CLAMP PLATE	1	206	OR90761	M5x10MM CHEESE HD SCREW	2
58	OR90927	M10 LOCK NUT	1	207	OR90381	M5 HEX NUT	2
59	OR71628	CAM ROD, INCL REF 60	1	208	OR90362	5.3MM EXT TOOTH WASHER	2
60	OR71629	HANDLE SLEEVE	1	209	OR71656	ELECTRIC-BOX-BRACKET	1
61	OR71630	COLLAR	1	210	OR71657	SWITCH	1
62	OR94197	EXT RET RING	1	221	OR71658	BELT	1
64	OR71631	LIVE CENTER ASSY, CONST OF REF 65,66,67,68,69,70,71,72,73,74, 75,76,77,78,79,80,81,82,83,84	1	222	OR71659	SPINDLE PULLEY, INCL REF 223	1
65	OR94198	WAVE WASHER	1	223	OR90222	M6x10MM HEX SOC SET SCREW	1
66	OR71632	LIVE CENTER	1	224	OR71660	MOTOR PULLEY, INCL REF 225	1
67	OR71610	CENTER POINT	1	225	OR90222	M6x10MM HEX SOC SET SCREW	1
68	OR71633	QUILL, INCL REF 69	1	226	OR70431	MOTOR, INCL REF 227 (5 SPEED)	1
69	OR71634	TAIL STOCK SCALE	1	227	OR70378	MOTOR LABEL (5 SPEED)	1
70	OR71635	SPINDLE SCREW	1	228	OR71661	OWNER'S MANUAL (NOT SHOWN)	1
71	OR94199	E-RING	1	229	OR71662	OWNER'S MANUAL SPANISH (NOT SHOWN)	1
72	OR71636	CAM ROD, INCL REF 73	1	230	OR71663	OWNER'S MANUAL FRNCH (NOT SHOWN)	1

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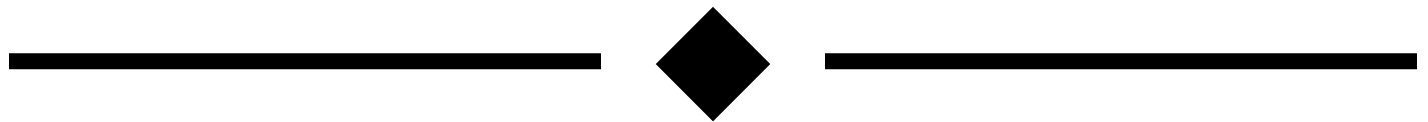


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